

Work Order ID 164418

Wednesday, July 19, 2017 10:30:16 AM

164418

Page 1

Item ID: D4646-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Plenum Cap Assembly
Start Date: 7/19/2017 Start Qty: 12.00 ***12*** Cust Item ID:
Required Date: 7/28/2017 Req'd Qty: 12.00 ***12*** Customer:
Reference:

Approvals: Process Plan: DAS Date: JUL 19 2017 Tooling: _____ Date: _____ Run Start ***NR1***
QC: 21 Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***
9-89

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4646	A

100

0.00

100

Purchasing

Purchasing

Memo

Issue P/O: 37159
Purchase Part Number: PC7041-1
Supplier: BIRK AEROSYSTEM CORPORATION
Certificate of conformity is required

0.00

12 JUL 20 2017 DAS
13

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Packaging

Memo

0.24

12x SP17 8-22

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER : _____							

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- All purchased or subcontracted products	0.00							
120									
QC	Memo	0.00				12			DAS 38 9-89
Quality Control									AUG 2 3 2017
130	Identify as per dwg & Stock Location	0.00							
130									
Packaging	Memo	0.12				12			DAS 6 9-89
Packaging									AUG 2 3 2017
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	1.20							DAS 21 9-89
Quality Control									AUG 2 4 2017

DAS
21
9-89
AUG 2 4 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Picklist Print

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Page 1

Work Order ID: 164418

164418

Parent Item: D4646-1

D4646-1

Parent Item Name: Plenum Cap Assembly

Start Date: 7/19/2017

Required Date: 7/28/2017

Start Qty: 12.00

Required Qty: 12.00

Comments: Ipp RevA 12.05.31 new issue EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

PC7041-1

Purchased

No

110

Each

0.0000

1

12

PC7041-1

Plenum Cap Assembly

12x SPA 8-22.

DQA: _____ Date: _____



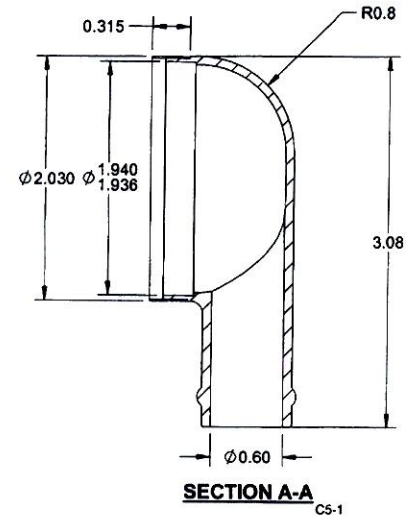
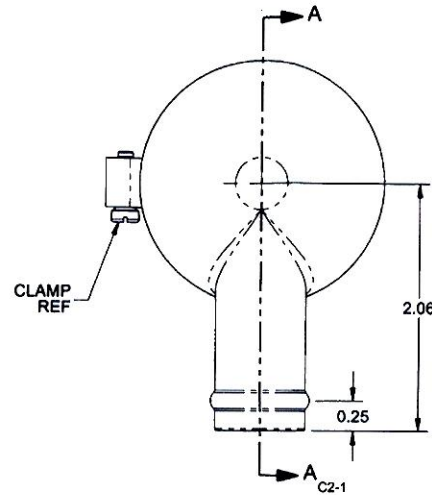
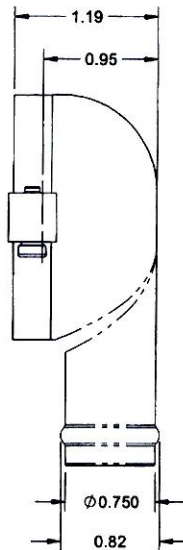
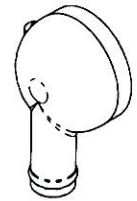
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Misidentified ☐	Past Due ☐																																																																

SPECIFICATION CONTROL DRAWING



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 164418 MJS
170719

DART PART NUMBER	DESCRIPTION	VENDOR	VENDOR PART NUMBER	WEIGHT (lbs)
D4646-1	PLENUM CAP WITH GEAR CLAMP	BIRK AEROSPACE CORPORATION	PC7041-1	0.05

D4646-X PLENUM CAP ASSEMBLY

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: PER TABLE

A	NEW ISSUE	RF	12.07.25
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. A
MFG. APPR.	RF	D4646	SHEET 1 OF 1
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	PLENUM CAP	NTS
DATE	12.07.25	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DQA: _____ Date: _____



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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO37159**

Purchase Order Date 7/20/2017 12:52:01 PM

PO Print Date 7/20/2017

Page Number 1 of 2

Order From :
BIRK AEROSYSTEMS CORPORATION
14321 COMMERCIAL DRIVE
GARDEN GROVE, CALIFORNIA 92843

VU-BIR001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

E-MAILED
JUL 20 2017

Contact Name
Vendor Phone 714-554-9782
Ship To Contact
Ship To Phone
Ship Via: FedEx Overnight collect
Ship Acct:

Buyer Chantal Lavoie
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency USD
FOB FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable CD Promise Date	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	PC7041-1 AS PER DWG D4646 REV. A B164418	Plenum Cap Assembly	8/29/2017 Yes 8/29/2017	12.00 Each	\$11.42	\$137.04
Line Total:						\$137.04
3	MN8005-1 AS PER DWG D4652 REV. D B164538	Mounting Nut	8/29/2017 Yes 8/29/2017	21.00 Each	\$14.65	\$307.65
Line Total:						\$307.65

Note:

7/20/2017

BAC**BIRK AEROSYSTEMS CORPORATION**

14321 Commerce Drive

Garden Grove, California 92843

Telephone: (714) 554-9782 Telefax: (714) 554-3659

DATE: 08/21/17

CUSTOMER PO: PO37159

SHIPPER NO.: DAR170821

CERTIFICATE OF CONFORMITY / PACKING LIST

SHIP TO: **DART AEROSPACE LTD**
1270 ABERDEEN
HAWKESBURY ON K6A 1K7
Canada

PO ITEM	PRODUCT NO.	DESCRIPTION	QUANTITY		LOT CODE	LOT QTY	SERIAL NO.
			ORDERED	SHIPPED			
1	PC7041-1	PLENUM CAP ASSEMBLY (REV. -)	12	12	1708363 MFG: 1733	12	-
2	MN8005-1	MOUNTING NUT (REV. -)	21	21	1704186 MFG: 1714	21	-
VALUE FOR CUSTOMS: \$444.69 USD Country of Manufacture: United States					SP7-822		

CLAIMS FOR SHORTAGES OR MATERIAL DISCREPANCY MUST BE MADE WITHIN 15 DAYS AFTER DATE SHIPPED.

CERTIFICATE OF CONFORMANCE: THIS IS TO CERTIFY THAT THE PARTS FURNISHED ON THIS ORDER HAVE BEEN FUNCTIONALLY TESTED IN ACCORDANCE WITH STANDARD PROCEDURES DEFINED BY BAC. MATERIAL AND/OR PARTS FURNISHED IN THIS ORDER HAVE BEEN MANUFACTURED IN ACCORDANCE WITH ALL APPLICABLE INSTRUCTIONS AND SPECIFICATIONS. PHYSICAL AND CHEMICAL DATA WHICH PERTAINS TO THIS ORDER ARE AVAILABLE FOR INSPECTION.

QTY VERF

**FEDEX S/O COLLECT****#3**
QUALITY CONTROL INSPECTOR